

Work Order ID 57878

Monday, April 19, 2010 3:33:37 PM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 4/19/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/4/20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2432	Rev F3

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

5/10/05/11

10/05/11

160

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

10-5-11

170

0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

5/10/05/11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



Item Name: Bearpaw

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Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 □ Location: 11

Rev A

10-5-12 10:28

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/05/12 7:2

mf

10-5-12

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Picklist Print

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Work Order ID: 57878



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:A New Issue 07-01-02 JLM
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-17A		Purchased	No			160	Each	982.0000	120.0000			
											10-5-11	
Bolt												

640

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST359	982	
112314	982	

D2182B		Manufactured	No			160	f	391.7530	25.0000			
Rubber Cushion												

120
 10-5-11 51 100

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST402A	9.67	
30872	9.67	
Main Warehouse		
ST410	382.083	
52649	382.083	

640

measured 810/640

Cut qty 6 at 5.00" long

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Bearpaw

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IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2274 <i>X12</i>		Manufactured	No			160	Each	248.0000	120.0000			
Radius Block											<i>10-5-11 S</i>	

S
710

Warehouse
Location

Main Warehouse

ST010 248
54850 100
56686 117
57254 31

62
58

D2432 *X2*



206 (24") Bearpaw

S
710

Manufactured No

160 Each 1.0000 20.0000



19
BS2015 10-5-11 S

Warehouse
Location

Main Warehouse

ST495 1
55485 1

1

D2438 *X16*



Clamp

S
710

Manufactured No

160 Each 133.0000 60.0000



10-5-11 S *(100)*

Warehouse
Location

Main Warehouse

ST456 133
55447 33
55603 100

33
27

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Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2529 <i>12</i>		Manufactured	No			160	Each	178.0000	120.0000			
Washer											<i>10-5-11</i>	<i>S</i>

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST017

178

56184

178

160

Each

1,593.000

120.0000

120

MS21042L4 *12*

Purchased

No

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

1591

113422

132

114108

951

114416

500

9063

8

120

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Shop Packet Print

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Dart Aerospace Ltd

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Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
NAS1149D0463J	124	Purchased	No			160	Each	1,319.000	240.0000			10-5-11
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST298

1319

113706

1319

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Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

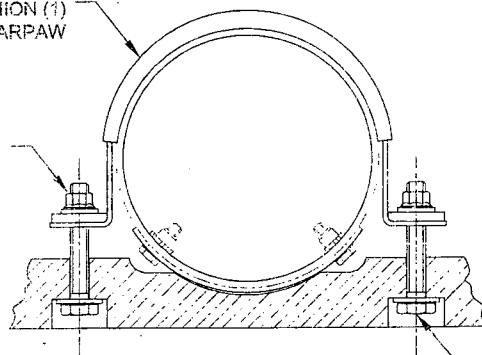
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



REFERENCE ONLY

ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050 /	Rubber Cushion
12	12	D2274 /	Radius Block
12	12	D2529 /	Washer
6	3	D2438 /	Clamp
1		D2432F /	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416 /	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F

Date: 08.08.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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